

Work Order ID 69991

Wednesday, May 25, 2011 10:57:11 AM



Page 1

Item ID: D4354-041
 Revision ID: ~~PRELIM~~ *Rev B*
 Item Name: Bearpaw Wearplate Assembly

Accept



Setup Start



Stop



Start Date: 5/25/2011 Start Qty: 4.00
 Required Date: 6/3/2011 Req'd Qty: 4.00



Cust Item ID:
 Customer:

Reference:

Approvals: Process Plan: *[Signature]* Date: *11-05-25* Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4354	<i>PAI</i> <i>Rev B</i> <i>E</i>								
100		0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
<i>304 .063</i>	1-Cut as per Dwg (D4354-1) Dwg Rev: <i>PAI</i> Prog Rev: <i>PAI</i>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

B11-5-25

(4)

Pro →

B11-5-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4353041 PAR #: _____ Fault Category: Production Engineer NCR: Yes No DQA: ck Date: 11/07/19
11-731 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 11-07-20

NCR: <u>69991</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/05/26</u>	<u>#100</u>	Parts are all scrap. They were cut with the wrong Rev in the program. Also the who was new up dates correctly.	<u>11.05.26</u> <u>QSI042</u>	→ Scrap + Destroy qty x4 And replace on <u>117653</u> Qty x4	<u>11-7-17</u>	<u>11/07/15</u>	<u>11.05.26</u> <u>QSI042</u>	<u>11/05/26</u>
		R.L. Parts were not correctly checked to day.	<u>11.05.26</u> <u>QSI042</u>	→ correctly up date who to remove problem. heading to market correct day.	<u>11.07.14</u>	<u>11/07/15</u>	<u>11.05.26</u> <u>QSI042</u>	<u>11/05/26</u>

NOTE: Date & initial all entries

Work Order ID 69991

Wednesday, May 25, 2011 10:57:11 AM



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Item ID: D4354-041

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Bearpaw Wearplate Assembly

Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

inspected to Rev B Dwg



0.00

8/10/11

QC

Memo

Quality Control

130

0.00



0.00

Large Fab

Memo

Large Fab

1- Weld cups as per dwg
A/R S.S. ROD BATCH: M114509.

2- Apply hardfacing on wearplate as indicated on dwg
A/R HARDCOAT 2059B BATCH: M118196

11-7-7

140

QC5- Inspect part completeness to step on W/O

0.00

8/10/11



0.00

QC

Memo

Quality Control

74

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 69991

Page 3

Wednesday, May 25, 2011 10:57:11 AM

Item ID: D4354-041 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Bearpaw Wearplate Assembly
Start Date: 5/25/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 6/3/2011 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							<i>Pl 11-07-08</i>
160  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							<i>11/7/8 SP (4)</i>
170  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>11/7/11 MF</i> <i>11-07-08</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 10:57:18 AM

Page 1

Work Order ID: 69991



Parent Item: D4354-041



Parent Item Name: Bearpaw Wearplate Assembly

Start Date: 5/25/2011

Required Date: 6/3/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.04.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

167.8000

0.9223

3.883368



304/316 Sheet .063



1311-5-25

Location

Loc Qty

Loc Code

MAT020

167.8

117275

7.8

117653

160

117653

D4379-1

Manufactured

No

130

Each

0.0000

10

40



Wearplate Cup



12 117-7(4)

40X .69 780

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Status	Item ID	Rev	Name	Quantity Per	UOM	Stop Date	Route Seq ID	Scrap %	rap Quant	Comments	Date Last Mod
✓	AN4C11A		bolt	8.0000	Each			0 %	0.0000		4/11/2011 10:43...
✓	AN4C16A		BOLT	8.0000	Each			0 %	0.0000		4/12/2011 12:39...
✓	AN4C22A		BOLT	4.0000	Each			0 %	0.0000		4/12/2011 12:39...
✓	D2274		Radius Block	12.0000	Each		110	0 %	0.0000		4/11/2011 10:43...
✓	D3456-1		Washer	8.0000	Each			0 %	0.0000		4/11/2011 10:43...
✓	D4176-1		429 Clamp, Top	4.0000	Each		110	0 %	0.0000		4/11/2011 10:43...
✓	D4212-1		429 Clamp Cus...	6.0000	Each			0 %	0.0000		4/11/2011 10:43...
✓	D4353-041	PRELIM	Bearpaw Asse...	2.0000	Each			0 %	0.0000		4/11/2011 10:43...
✓	D4354-041	PRELIM	Bearpaw Wear...	2.0000	Each			0 %	0.0000		4/11/2011 10:43...
✓	D4382-1	PRELIM	Angled Bearpa...	2.0000	Each			0 %	0.0000		4/11/2011 10:43...
✓	MS21043-4		Nut	20.0000	Each			0 %	0.0000		4/11/2011 10:43...
✓	NAS1149D0463J		Washer	12.0000	Each			0 %	0.0000		4/11/2011 10:43...

Still shows
prelim Done

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4354-041	429 BEARPAW WEARPLATE ASSEMBLY
1	1	D4354-1	429 BEARPAW WEARPLATE
2	10	D4379-1	WEARPLATE CUP
3	A/R	2059B	HARDCOAT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69991

PM-0525

D4354-041 429 BEARPAW WEARPLATE ASSEMBLY

RELEASED
2011-05-26

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4354-041" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 1.76 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 12 PL

B	SHT 3. LIGHTENING HOLES DELETED. SHT 2 ZONE B1 & B6 HARDCOAT RELOCATED. REASON: PROTECTION OF BEARPAW.	AJS	11.05.16
A	NEW ISSUE	AJS	11.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4354	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	429 BEARPAW WEARPLATE ASSEMBLY	NTS
DATE	11.05.16	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

10 PL 2

1

C SYM ABOUT

0.375 TYP

0.06 MIN
0.13 MAX

0.13 TYP

SECTION A-A C1-2
SCALE 2X

3

0.94

1.38

2.50
3 PL

2.13
TYP

1.88

B 0.70

B 0.60

C SYM ABOUT

RELEASED
2011-05-26
JW

D4354-041 429 BEARPAW WEARPLATE ASSEMBLY

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4354 TITLE 429 BEARPAW WEARPLATE ASSEMBLY SCALE NTS COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT PERMISSION FROM DART AEROSPACE LTD.
DRAWN	AJS	
CHECKED	<i>[Signature]</i>	
MFG. APPR.	<i>[Signature]</i>	
DE APPR.	<i>[Signature]</i>	
DATE	11.05.16	REV. B SHEET 2 OF 3

RELEASED
2011-05-26
UMB

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4354	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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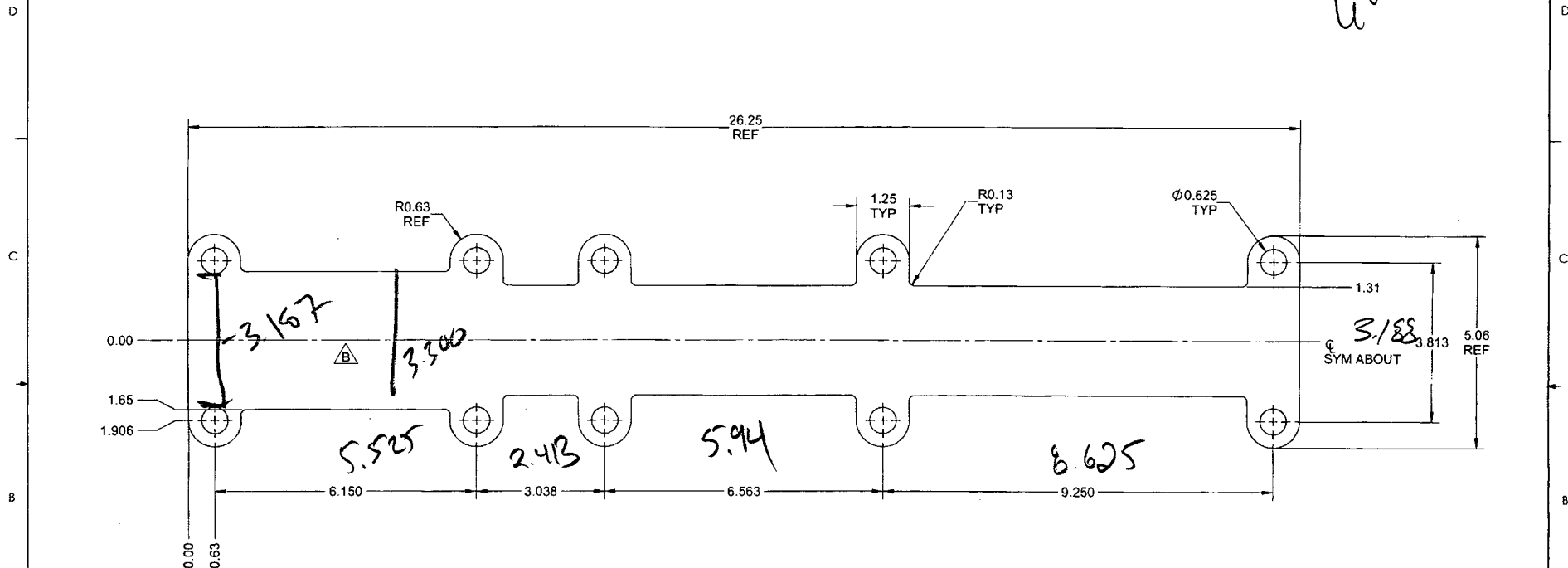
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4354-1 429 BEARPAW WEARPLATE

RELEASED
2011-05-24

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.52 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4354	REV. B
MFG. APPR.	<i>[Signature]</i>		SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	429 BEARPAW WEARPLATE ASSEMBLY	NTS
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